

ml



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

D2573
Job Sheet 172064



Tel (613) 632-5200

Part No: D2573 Job Qty: 12 ea

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs Status: Scheduled Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/19/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		2/16/18	0.00	0.00	Start Up Machining		<i>VH 18/03/18</i>
100	CNC Vertical Machining	12 pcs		2/17/18	1.01	20.00	HAAS 1		<i>SBL 18/03/18</i>
110	Mill Conv	12 pcs		2/17/18	0.00	2.00	Mill Conv 1		<i>SBL 18/03/18</i>
130	QC	12 pcs		2/17/18	0.00	0.00	QC8		<i>QC 2, 18-03-13</i>
140	HandFinish	12 pcs		2/17/18	0.00	0.56	HandFinish1		<i>SA 18-3-13</i>
150	Powdercoat	12 pcs		2/19/18	0.00	0.46	Powdercoat1		<i>PK 18-3-13</i>
160	QC	12 pcs		2/19/18	0.00	0.00	QC3		<i>9-11 MAR 16 2018</i>
170	Packaging	12 pcs		2/19/18	0.00	0.00	Packaging3		<i>9-11 MAR 16 2018</i>
180	QC21-SA	12 Ea		2/19/18	0.00	0.00	QC21		<i>9-11 MAR 16 2018</i>

Part Op 100 - Program Batch No. _____
Descriptions: 110 - Machine keyway as per dwg D2573 & D2574
150 - START TIME: *10:45 ON 18-03-18 FINISH: 11:15* *M 12877-13 8760*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	12 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	12	48	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Aft Outboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Aft Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490		

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P.T.O.

7	Saddle, Aft Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Outboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Outboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Outboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Aft Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Outboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

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DART AEROSPACE LTD		Work Order: 172064
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.505		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.569	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.125	4.125	4.124		
P	0.115	0.135		.130	.130	.128	.132		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.253	.253	.252	.253		
S	0.115	0.135		.125	.125	.124	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.229	3.229	3.230	3.230		
V	0.230	0.250		.241	.240	.240	.241		
W	0.115	0.135		.126	.126	.126	.126		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.070	.066	.068	.070		
AD	0.240	0.260		.252	.251	.251	.251		
AE	1.500	1.520		1.500	1.500	1.500	1.500		
AF	0.115	0.135		.120	.121	.120	.122		
AG	0.240	0.280		.255	.252	.252	.250		
AH	0.240	0.260		.250	.250	.252	.249		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SBL	DAS	Audited by:
Date: 18/03/03	39	Date:
	8-00	

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 172064
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page: 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	37	48		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.501	.500	.501		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.500	.500	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.568	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.125	4.124		
P	0.115	0.135		.126	.130	.133	.126		
Q	0.115	0.135		.125	.125	.124	.125		
R	0.240	0.260		.252	.253	.252	.253		
S	0.115	0.135		.125	.127	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.241	.241	.241	.241		
W	0.115	0.135		.127	.127	.125	.125		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.363	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.068	.070	.068	.070		
AD	0.240	0.260		.251	.251	.251	.252		
AE	1.500	1.520		1.500	1.500	1.500	1.500		
AF	0.115	0.135		.120	.118	.120	.120		
AG	0.240	0.280		.253	.252	.252	.250		
AH	0.240	0.260		.249	.250	.250	.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SBL	Audited by:
Date: 18/03/03	Date:

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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DART AEROSPACE LTD		Work Order: 172064
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 3 of 3

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	311	412		
A	0.438	0.443			.438	.438	.438		
B	1.745	1.755			1.750	1.750	1.750		
C	3.495	3.505			3.500	3.500	3.500		
D	1.745	1.755			1.750	1.750	1.750		
E	7.990	8.010			8.000	8.000	8.000		
F	0.490	0.510			.5000	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.132	.130	.130	.133		
Q	0.115	0.135		.124	.125	.125	.125		
R	0.240	0.260		.253	.252	.252	.252		
S	0.115	0.135		.127	.127	.127	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.126	.126	.127	.126		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.363	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.070	.070	.067	.070		
AD	0.240	0.260		.252	.251	.251	.252		
AE	1.500	1.520		1.500	1.500	1.500	1.500		
AF	0.115	0.135		.122	.120	.125	.122		
AG	0.240	0.280		.246	.250	.250	.250		
AH	0.240	0.260		.250	.250	.252	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SBL	Audited by:
Date: 18/03/04	Date:

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

MD 18 Jun 2019



DQA: _____ Date: 18/03/08

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 172064		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																																
Part No. D2573		Rework ☒ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☒ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐																																																																										
NCR No. 19-7160		Suspected Unapproved		QTY Effective: 1																																																																																
Date: 18.3.5		Step #: 100		MRB (Q51042) Approval PD 18.3.5																																																																																
Description Work Order Deviation				Disposition																																																																																
the Ø, 438 holes are off-center "F" measurement must be at 0,500±0,010 the measure on the piece is 0,401				Scrap destroy no replace																																																																																
Root Cause				FAULT CATEGORY																																																																																
<table><tr><td>Environment</td><td>No Re-verification</td><td>Pressure/Forced</td><td>Temperature/Cure</td><td>Power Loss/Surge</td><td>Positioned Wrong</td></tr><tr><td>Design</td><td>☒</td><td>Bending</td><td>Set-up</td><td>Folio/Program</td><td>Outside Dimensions</td></tr><tr><td>Doc/Data</td><td>Offset/Setup</td><td>Centre Not Concentric</td><td>BOM/Route</td><td>Grain</td><td>Over/Under tolerance</td></tr><tr><td>Equip/Tooling</td><td>Supplier</td><td>Cracks</td><td>Broken/Damage/Defect</td><td>Weld</td><td>Part Incorrect</td></tr><tr><td>Handling/Pre</td><td>Training</td><td>Crimp/Kink/Ripple/Wave</td><td>Inspection Incomplete/Unqualified</td><td>Wrong Stock Pulled</td><td>Part Lost/Missing</td></tr><tr><td>Material</td><td>Use for Testing</td><td>Cuffs</td><td>Contamination</td><td>Out of Sequence</td><td>Part Moved</td></tr><tr><td>Internal Transport</td><td>Poor Information</td><td>Crushing</td><td>Countersink</td><td>Off-set</td><td>Drawing</td></tr><tr><td>Tribal Knowledge</td><td>Rushing</td><td>Heat Treat</td><td>Cut Too Short</td><td>Mislabeled</td><td>Finish</td></tr><tr><td>LOA</td><td>Product Improvement</td><td>Wave/Twist in Tube</td><td>Instructions Incomplete/Unclear</td><td>Fit/Function</td><td>Misread</td></tr><tr><td>Substation</td><td>Process Improvement</td><td>Marks/Chatter</td><td>Drill Holes</td><td>Misaligned/off center</td><td>Turning Sequence</td></tr><tr><td>Past Expiry Date</td><td>Manufacturing Process</td><td></td><td></td><td></td><td></td></tr><tr><td>Misidentified</td><td>Past Due</td><td></td><td></td><td></td><td></td></tr></table>				Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong	Design	☒	Bending	Set-up	Folio/Program	Outside Dimensions	Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect	Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing	Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved	Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing	Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish	LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread	Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence	Past Expiry Date	Manufacturing Process					Misidentified	Past Due					<table><tr><td>OTHER :</td></tr></table>								OTHER :
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong																																																																															
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